

#### Work Order ID 62409

September 29, 2010 12:51:37 PM

Item ID:

D3561-1

Accept

Setup Start

**Revision ID:** 

Item Name:

Seal Insert Tool

**Start Date:** 9/29/10 **Start Qty: 10.00** 

**Cust Item ID:** 

Required Date: 10/01/10

**Reg'd Qty:** 10.00

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Start Run

Stop

Stop

OC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID Operation Description Set Up/

Tool ID

Tool # Plan

Reject Accept

Reject

Insp.

**Draw Nbr** 

FLOW CNC Waterjet

**Revision Nbr** 

**Run Hours** 

Code Qty

Qty

Number

Stamp

D3561

- 100

Rev A

0.00

FLOW WATER JET

Waterjet

Memo

0.00

1-Cut as per Dwg D3561 + Dwg Rev: Deburr if necessary

B10-9-34

(De

QC2- Inspect parts off machine FAI/FAIB

0.00

1B10-9- 29

QC

110

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

0.00

Quality Control

Memo

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
				i			·					

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	<u> </u>	Disposition:	QA: N/C Closed:	Date:

	To Tree T	WORK OR	DER NON-CONFORMANO	CE (NCR)			
	Description of NC		Corrective Action Section B	•	Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	Arms Ass. 1500 He - Instrument						
	1 444						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP  Description of NC Section A  Corrective Action Section B  Initial Chief Eng Chief Eng Chief Eng	STEP  Description of NC Section A  Initial Action Description Chief Eng Chie	STEP  Description of NC Section A  Description of NC Section A  Chief Eng  Corrective Action Section B  Initial Action Description Chief Eng Chief Eng  Verification Section C  Section C	STEP Description of NC Section A Description Chief Eng C

NOTE: Date & initial all entries

# Work Order ID 62409

September 29, 2010 12:51:37 PM

QC

Quality Control

Item ID: D3561-1 Accept Setup Start **Revision ID:** Stop Seal Insert Tool Item Name: 9/29/10 **Start Qty: 10.00 Start Date: Cust Item ID:** Required Date: 10/01/10 Req'd Qty: 10.00 **Customer:** Reference: Start Run Approvals: **Tooling: Process Plan:** Date: Date: Stop QC: Date: SPC (Y/N): Date: Tool ID Sequence ID/ Operation Set Up/ Reject Reject Tool # Plan Accept Insp. Work Center ID Qty Qty Stamp Description **Run Hours** Code Number 130 0.00 Small Fab 0.00 Small Fab Memo Small Fab Deburr if necessary. 0.00 140 NC BRAKE Brake NC Memo Brake NC Form as per Dwg D3561 150 QC5- Inspect part completeness to step on W/O

0.00

Memo

Dart Ae	rospace	e Ltd								*
W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PRC	NGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			,							
Part No	:	PAR #:	Fault Cate	gory:	NCI	R: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposition	າ:	QA	N/C CIG	sed:		Date: _	
NCR:		1	WORK ORDE	ER NON-CONFO	RMANCE	(NCR	)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Descrip  Chief Eng	otion	Sign & Date		on C	Chief Eng	QC Inspector
		,								
			, ,	,						

NOTE: Date & initial all entries

#### Work Order ID 62409

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September 29, 2010 12:51:37 PM

Item ID: D3561-1 Accept Setup Start **Revision ID:** Stop Item Name: Seal Insert Tool **Start Date:** 9/29/10 **Start Qty: 10.00 Cust Item ID:** Required Date: 10/01/10 Req'd Qty: 10.00 **Customer:** Reference: Start Run **Approvals: Process Plan:** Date: **Tooling:** Date: Stop QC: Date: **SPC (Y/N):** Date: Operation Sequence ID/ Set Up/ Reject Tool ID Tool # Plan Reject Accept Work Center ID Description Run Hours Qty Number Stamp Code Identify as per dwg & Stock Location: 6+ 160 0.00 Packaging 0.00 Memo Packaging

170 QC21- Final Inspection - Work Order Release 0.00

QC 0.00 Memo

**Quality Control** 

10/10/04 A) Mr. 0-10-04

Insp.

## **Picklist Print**

September 29, 2010 12:51:36 PM

Work Order ID: 62409

Parent Item:

D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 9/29/10

Required Date: 10/01/10

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP: A 06.10.19 New issue! EC:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last . Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	63.9423	0.0473	0.497895	رک	7	
304/316 0.125 Sheet											1B10-9	- 99	
				Location		Loc (	<u>Oty</u>	Loc Code					
				MAT		63.9	423		_		1	14	
					114799	63.9	423			14799	'	٣	

## **Dart Aerospace Ltd**

W/O: WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1
<del></del>								
Part No	:	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Resolution:		Disposition:	QA: N/C	Closed:		Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section B Action Description	Sign & Verification Section C		Approval Chief Eng	Approval QC Inspector					
			Chief Eng	Chief Eng	Date			do mopositi					
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						<del></del>		;					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62407
Description: Seal Insert Tool	Part Number:	D3561-1
Inspection Dwg: D3561 Rev: A		Page 1 of 1

	FIR	ST ARTICLE	INSPECT	ION CH	ECKLIST		
		X First Ar	ticle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
1.00	+/-0.030	1,008	*		V BOS	)	
2.777	+/-0.010	2.780	8		<b>V</b>		
0.57	+/-0.030	, 561	9		V		
R0.06	+/-0.030	66	*		R.G		
R0.28	+/-0.030	98	×		R.6		
0.075	+/-0.030	.013	**		V		
							-
· · · · · · · · · · · · · · · · · · ·							
			,				
	74-74						
				- · · · ·			
				7			
leasured by:	B	Audited by:			Prototype A	pproval:	N/A
Date:	10-9-39	Date:	1009.3	50		Date:	N/A
ev Date	Change				F	Revised by	Approved
A 07.05.10	New Issue				K	(J/JLM 🚓	B

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